

CLAIMS

I claim:

- [c1] 1. A corrugated container body comprising:
an outer tube having at least four outer side panels foldably connected to each other, at least two of the outer side panels being foldably connected to each other along an outer corner portion that includes a first score line offset from a second score line by a first offset distance; and
an inner tube having at least four inner side panels foldably connected to each other, at least two of the inner side panels being foldably connected to each other along an inner corner portion that includes a third score line offset from a fourth score line by a second offset distance, the inner tube being sleeved within the outer tube with each of the inner side panels being directly adjacent to an outer side panel in one-to-one correspondence.
- [c2] 2. The corrugated container body of claim 1 wherein the outer tube has eight outer side panels.
- [c3] 3. The corrugated container body of claim 1 wherein the first offset distance is greater than the second offset distance.
- [c4] 4. The corrugated container body of claim 1 wherein each of the at least four outer side panels include first and second plies and each of the at least four inner side panels include third, fourth, and fifth plies.
- [c5] 5. The corrugated container body of claim 4 wherein the first, second, third, fourth and fifth plies are double-wall corrugated paperboard.

[c6] 6. The corrugated body of claim 1 wherein the outer tube includes a top portion and a bottom portion and further includes at least four bottom flaps foldably extending from adjacent outer side panels in one-to-one correspondence with the outer side panels.

[c7] 7. The corrugated container body of claim 6 wherein each of the at least four outer side panels includes first and second plies and the at least four bottom flaps foldably extend from the first ply, the first ply being outboard of the second ply.

[c8] 8. The corrugated container body of claim 1 wherein each of the at least four outer side panels has an outer side panel thickness and each of the at least four inner side panels has an inner side panel thickness, wherein the first offset distance is determined based on the outer side panel thickness and the inner side panel thickness, and wherein the second offset distance is determined based on the inner side panel thickness.

[c9] 9. The corrugated container body of claim 8 wherein the first offset distance is at least approximately equal to $0.30 \times (\text{thickness of the outer tube}) + 2 \times (\text{thickness of the inner tube})$ and the second offset distance is at least approximately equal to $1.5 \times (\text{thickness of the inner tube})$.

[c10] 10. The corrugated container body of claim 1 wherein each of the at least four outer side panels includes first and second plies and each of the at least four inner side panels includes third, fourth, and fifth plies, wherein the first, second, third, fourth and fifth plies are double-wall corrugated paperboard, and wherein the first offset distance is between 2.0 and 3.0 inches and the second offset distance is between 1.25 and 2.25 inches.

[c11] 11. The corrugated container body of claim 10 wherein the first offset distance is between 2.3 and 2.7 inches and the second offset distance is between 1.5 and 2.0 inches.

[c12] 12. The corrugated container body of claim 1 wherein the inner tube has an inner tube inner surface and an inner tube outer surface and the outer tube has an outer tube inner surface and an outer tube outer surface, and wherein the first and second score lines are formed on the outer tube inner surface and the third and fourth score lines are formed on the inner tube inner surface.

[c13] 13. The corrugated container body of claim 1 wherein the inner tube has an inner tube inner surface and an inner tube outer surface and the outer tube has an outer tube inner surface and an outer tube outer surface, and wherein the first and second score lines are formed on the outer tube outer surface and the third and fourth score lines are formed on the inner tube outer surface.

[c14] 14. A foldable corrugated container structure comprising:
an outer laminate forming at least a first outer panel and a second outer panel, the outer laminate having a first score line offset from a second score line by a first offset distance, the first and second score lines being positioned between the first and second outer panels; and
an inner laminate forming at least a first inner panel and a second inner panel, the inner laminate having a third score line offset from a fourth score line by a second offset distance, the third and fourth score lines being positioned between the first and second inner panels, wherein the inner laminate is at least partially bonded to the outer laminate with the first inner panel positioned adjacent to the first outer panel to form a first wall and the second inner panel positioned adjacent to the second outer panel to form a second wall,

wherein the first and second score lines of the outer laminate and the third and fourth score lines of the inner laminate together define a corner portion, and wherein the first and second walls are foldable toward each other about the corner portion.

[c15] 15. The corrugated container structure of claim 14 wherein the first offset distance is greater than the second offset distance.

[c16] 16. The corrugated container structure of claim 14 wherein the outer laminate includes first and second plies and the inner laminate includes third, fourth and fifth plies.

[c17] 17. The corrugated container structure of claim 16 wherein the first, second, third, fourth and fifth plies are double-wall corrugated paperboard.

[c18] 18. The corrugated container structure of claim 14 wherein the outer laminate includes first and second plies and the inner laminate includes third and fourth plies, the first, second, third and fourth plies being triple-wall corrugated paperboard.

[c19] 19. The corrugated container structure of claim 14 wherein the outer laminate has an outer laminate thickness and the inner laminate has an inner laminate thickness, wherein the first offset distance is determined based on the outer laminate thickness and the inner laminate thickness and the second offset distance is determined based on the inner laminate thickness.

[c20] 20. The corrugated container structure of claim 19 wherein the first offset distance is at least approximately equal to $0.30 \times (\text{thickness of the outer laminate}) + 2 \times (\text{thickness of the inner laminate})$ and the second offset distance is at least approximately equal to $1.5 \times (\text{thickness of the inner laminate})$.

[c21] 21. The corrugated container structure of claim 14 wherein the inner laminate has an inner laminate inner surface and an inner laminate outer surface and the outer laminate has an outer laminate inner surface and an outer laminate outer surface, and wherein the first and second score lines are formed on the outer laminate inner surface and the third and fourth score lines are formed on the inner laminate inner surface.

[c22] 22. The corrugated container structure of claim 14 wherein the inner laminate has an inner laminate inner surface and an inner laminate outer surface and the outer laminate has an outer laminate inner surface and an outer laminate outer surface, and wherein the first and second score lines are formed on the outer laminate outer surface and the third and fourth score lines are formed on the inner laminate outer surface.

[c23] 23. A liner tray usable with a liner for holding liquids, the liner including a drain fitment for dispensing the liquids, the drain fitment having a neck portion and a flange adjacent to the neck portion, the liner tray comprising:

- a base member; and
- a fitment retainer extending from the base member, the fitment retainer including first, second, and third fitment apertures, the first and second fitment apertures each having an oversize portion and an engagement portion, the oversize portions being shaped and sized to permit passage of the flange of the drain fitment and the engagement portions being shaped and sized to receive the neck portion of the drain fitment, the first and second fitment apertures being positionable in at least approximate alignment with each other, the third fitment aperture being shaped and sized to releasably receive the neck portion of the drain fitment, the third fitment aperture being positionable in at least approximate alignment with the engagement portions of the first and second fitment apertures.

[c24] 24. The liner tray of claim 23 wherein the engagement portions of the first and second fitment apertures are shaped and sized to receive and engage the neck portion of the drain fitment.

[c25] 25. The liner tray of claim 23 wherein the neck portion of the drain fitment has a cross-sectional shape and the engagement portions of the first and second fitment apertures have at least partially the same cross-sectional shape as the neck portion, and wherein the engagement portions of the first and second fitment apertures are shaped and sized to receive and engage the neck portion of the drain fitment.

[c26] 26. The liner tray of claim 23 wherein the neck portion of the drain fitment has a cross-sectional shape and the engagement portions of the first and second fitment apertures and the third fitment aperture have at least partially the same cross-sectional shape as the neck portion, and wherein the engagement portions of the first and second fitment apertures and the third fitment aperture are shaped and sized to receive and engage the neck portion of the drain fitment.

[c27] 27. The liner tray of claim 23 wherein the fitment retainer further includes a plurality of slits extending radially from the third fitment aperture sized to allow the third fitment aperture to pass over the flange of the drain fitment and releasably receive the neck portion of the drain fitment.

[c28] 28. The liner tray of claim 23 wherein the fitment retainer extends from the base member along a fold line, and wherein the liner tray further comprises a relief slit at least approximately aligned with the fold line and adjacent to the first fitment aperture.

[c29] 29. The liner tray of claim 23 wherein the base member and the fitment retainer are fabricated from non-corrugated paperboard.

[c30] 30. The liner tray of claim 23 wherein the first and second fitment apertures have keyhole shapes.

[c31] 31. The liner tray of claim 23 wherein the third fitment aperture has a generally rectangular shape, and wherein a slit extends diagonally from each corner of the third fitment aperture and a slit extends perpendicularly from each side of the third fitment aperture.

[c32] 32. The liner tray of claim 23 wherein the neck portion of the drain fitment has a rectangular cross-section and the engagement portions of the first and second fitment apertures are shaped and sized to receive and engage the neck portion of the drain fitment..

[c33] 33. The liner tray of claim 23 wherein the fitment retainer foldably extends from the base member along a fold line, wherein the first and second fitment apertures are foldably positionable in at least approximate alignment with each other, and wherein the third fitment aperture is foldably positionable in at least approximate alignment with the engagement portions of the first and second fitment apertures.

[c34] 34. A liner tray usable with a liner for holding liquids, the liner including a drain fitment for dispensing the liquids, the liner tray comprising:

a base member;

a first fitment retainer panel extending from the base member along a first fold line, the first fitment retainer panel having a first fitment aperture shaped and sized to receive the drain fitment;

a second fitment retainer panel extending from the first fitment retainer panel along a second fold line that is at least approximately parallel to the first fold line, the second retainer panel having a second fitment aperture shaped and sized to receive the drain fitment, the

second fitment retainer panel being foldable about the second fold line to position the second fitment aperture adjacent to the first fitment aperture; and

a third fitment retainer panel extending from the second fitment retainer panel along a third fold line that is at least approximately perpendicular to the first and second fold lines, the third fitment retainer having a third fitment aperture shaped and sized to receive the drain fitment, wherein the third fitment retainer panel is foldable about the third fold line to position the third fitment aperture adjacent to the first and second fitment apertures.

[c35] 35. The liner tray of claim 34 wherein the third fitment retainer panel further includes a plurality of slits extending radially from the third fitment aperture sized to allow the third fitment aperture to pass over at least a portion of the drain fitment.

[c36] 36. The liner tray of claim 34 further comprising a relief slit at least approximately aligned with the first fold line and adjacent to the first fitment aperture.

[c37] 37. The liner tray of claim 34 wherein the base member and the first, second, and third fitment retainer panels are fabricated from non-corrugated paperboard.

[c38] 38. The liner tray of claim 34 wherein the first and second fitment apertures have keyhole shapes.

[c39] 39. The liner tray of claim 34 wherein the third fitment aperture has a generally rectangular shape, and wherein a slit extends diagonally from each

corner of the third fitment aperture and a slit extends perpendicularly from each side of the third fitment aperture.

[c40] 40. The liner tray of claim 34 wherein the drain fitment includes a neck portion and a flange adjacent to the neck portion, wherein:

the first and second fitment apertures each have an oversize portion and an engagement portion, the oversize portions being shaped and sized to permit passage of the flange of the drain fitment and the engagement portions being shaped and sized to receive and engage the neck portion of the drain fitment; and

the third fitment aperture is shaped and sized to releasably receive the neck portion of the drain fitment, the third fitment aperture being positionable in at least approximate alignment with the engagement portions of the first and second fitment apertures.

[c41] 41. The liner tray of claim 40 wherein the first and second fitment apertures have keyhole shapes and the third fitment aperture has a generally rectangular shape, and wherein a slit extends diagonally from each corner of the third fitment aperture and a slit extends perpendicularly from each side of the third fitment aperture.

[c42] 42. The liner tray of claim 40 wherein the neck portion of the drain fitment has a rectangular cross-section.

[c43] 43. A corrugated container assembly usable for holding liquids, the container assembly comprising:

a container body including a plurality of vertical side walls foldably connected to each other to define top and bottom portions of the container body, at least two of the vertical side walls being foldably connected to each other along a corner portion that includes a first

score line offset from a second score line, wherein one of the vertical side walls includes a fitment opening positioned toward the bottom portion of the container body;

a liner tray including a base member and a fitment retainer extending from the base member, the liner tray being positionable within the vertical side walls of the container body toward the bottom portion of the container body; and

a flexible and impervious liner including a drain fitment for dispensing liquids, the liner being positioned on the liner tray within the vertical side walls of the container body, the drain fitment being engaged with the fitment retainer adjacent to the fitment opening in the container body.

[c44] 44. The corrugated container assembly of claim 43 wherein the container body has eight vertical side walls.

[c45] 45. The corrugated container assembly of claim 43 wherein the drain fitment includes a neck portion and a flange adjacent to the neck portion, and wherein the fitment retainer includes first, second, and third fitment apertures, the first and second fitment apertures each having an oversize portion and an engagement portion, the oversize portions being shaped and sized to permit passage of the flange of the drain fitment and the engagement portions being shaped and sized to receive and engage the neck portion of the drain fitment, the first and second fitment apertures being positionable in at least approximate alignment with each other, the third fitment aperture being shaped and sized to releasably receive the neck portion of the drain fitment, the third fitment aperture being positionable in at least approximate alignment with the engagement portions of the first and second fitment apertures.

[c46] 46. The corrugated container assembly of claim 45 wherein the fitment retainer further includes a plurality of slits extending radially from the third fitment aperture sized to allow the third fitment aperture to pass over the flange of the drain fitment and releasably receive the neck portion of the drain fitment.

[c47] 47. The corrugated container assembly of claim 45 wherein the liner tray further comprises a relief slit at least approximately aligned with the fold line and adjacent to the first fitment aperture.

[c48] 48. The corrugated container assembly of claim 45 wherein the first and second fitment apertures have keyhole shapes.

[c49] 49. The corrugated container assembly of claim 45 wherein the neck portion of the drain fitment has a rectangular cross-section.

[c50] 50. The corrugated container assembly of claim 45 wherein the neck portion of the drain fitment has a rectangular cross-section, wherein the third fitment aperture has a generally rectangular shape, and wherein a slit extends diagonally from each corner of the third fitment aperture and a slit extends perpendicularly from each side of the third fitment aperture.

[c51] 51. The corrugated container assembly of claim 43 wherein the liner tray is fabricated from non-corrugated paperboard.

[c52] 52. The corrugated container assembly of claim 43 wherein the fitment retainer includes a first fitment retainer panel, a second fitment retainer panel, and a third fitment retainer panel, wherein the fold line is a first fold line and the first fitment retainer panel extends from the base member along the first fold line, the first fitment retainer panel having a first fitment aperture shaped and sized to receive the drain fitment, wherein the second fitment retainer panel extends from

the first fitment retainer panel along a second fold line that is at least approximately parallel to the first fold line, the second retainer panel having a second fitment aperture shaped and sized to receive the drain fitment, the second fitment retainer panel being foldable about the second fold line to position the second fitment aperture adjacent to the first fitment aperture, and wherein the third fitment retainer panel extends from the second fitment retainer panel along a third fold line that is at least approximately perpendicular to the first and second fold lines, the third fitment retainer having a third fitment aperture shaped and sized to receive the drain fitment, wherein the third fitment retainer panel is foldable about the third fold line to position the third fitment aperture adjacent to the first and second fitment apertures.

[c53] 53. The corrugated container assembly of claim 52 wherein the third fitment retainer panel further includes a plurality of slits extending radially from the third fitment aperture sized to allow the third fitment aperture to pass over at least a portion of the drain fitment.

[c54] 54. The corrugated container assembly of claim 52 wherein the liner tray further comprises a relief slit at least approximately aligned with the first fold line and adjacent to the first fitment aperture.

[c55] 55. The corrugated container assembly of claim 52 wherein the first and second fitment apertures have keyhole shapes.

[c56] 56. The corrugated container assembly of claim 52 wherein the third fitment aperture has a generally rectangular shape, and wherein a slit extends diagonally from each corner of the third fitment aperture and a slit extends perpendicularly from each side of the third fitment aperture.

[c57] 57. The corrugated container assembly of claim 52 wherein the drain fitment includes a neck portion and a flange adjacent to the neck portion, wherein first and second fitment apertures each have an oversize portion and an engagement portion, the oversize portions being shaped and sized to permit passage of the flange of the drain fitment and the engagement portions being shaped and sized to receive and engage the neck portion of the drain fitment, and wherein the third fitment aperture is shaped and sized to releasably receive the neck portion of the drain fitment, the third fitment aperture being positionable in at least approximate alignment with the engagement portions of the first and second fitment apertures.

[c58] 58. The corrugated container assembly of claim 43 wherein the container body includes an outer tube and an inner tube, the outer tube having a plurality of outer side panels foldably connected to each other, at least two of the outer side panels being foldably connected to each other along an outer corner portion that includes the first score line offset from the second score line by a first offset distance, the inner tube having a plurality of inner side panels foldably connected to each other, at least two of the inner side panels being foldably connected to each other along an inner corner portion that includes a third score line offset from a fourth score line by a second offset distance, the inner tube being sleeved within the outer tube to form the plurality of vertical side walls foldably connected to each other.

[c59] 59. The corrugated container assembly of claim 58 wherein the first offset distance is greater than the second offset distance.

[c60] 60. The corrugated container assembly of claim 58 wherein the outer tube includes first and second plies and the inner tube includes third, fourth, and fifth plies.

[c61] 61. The corrugated container assembly of claim 58 wherein the first, second, third, fourth and fifth plies are double-wall corrugated paperboard.

[c62] 62. The corrugated container assembly of claim 58 wherein the inner tube has an inner tube inner surface and an inner tube outer surface and the outer tube has an outer tube inner surface and an outer tube outer surface, and wherein the first and second score lines are formed on the outer tube inner surface and the third and fourth score lines are formed on the inner tube inner surface.

[c63] 63. A corrugated container assembly usable for holding liquids, the container assembly comprising:

a container body including a plurality of vertical side walls foldably connected to each other to define top and bottom portions of the container body, at least two of the vertical side walls being foldably connected to each other along a corner portion that includes a first score line offset from a second score line, wherein one of the vertical side walls includes a fitment opening positioned toward the bottom portion of the container body;

a flexible and impervious liner including a drain fitment for dispensing liquids, the drain fitment having a neck portion and a flange adjacent to the neck portion, the liner being positionable within the vertical sidewalls of the container body; and

a liner tray including a base member and a fitment retainer extending from the base member, the fitment retainer including first, second, and third fitment apertures, the first and second fitment apertures each having an oversize portion and an engagement portion, the oversize portions being shaped and sized to permit passage of the flange of the drain fitment and the engagement portions being shaped and sized to receive the neck portion of the drain fitment, the first and

second fitment apertures being positionable in at least approximate alignment with each other, the third fitment aperture being shaped and sized to releasably receive the neck portion of the drain fitment, the third fitment aperture being positionable in at least approximate alignment with the engagement portions of the first and second fitment apertures, the liner tray being positionable within the vertical side walls of the container body toward the bottom portion of the container body, the liner being positionable on the liner tray within the vertical side walls of the container body, the drain fitment being engaged with the fitment retainer adjacent to the fitment opening in the container body.

[c64] 64. The corrugated container assembly of claim 63 wherein the container body has eight vertical side walls.

[c65] 65. The corrugated container assembly of claim 63 wherein the fitment retainer further includes a plurality of slits extending radially from the third fitment aperture sized to allow the third fitment aperture to pass over the flange of the drain fitment and releasably receive the neck portion of the drain fitment.

[c66] 66. The corrugated container assembly of claim 63 wherein the fitment retainer extends from the base member along a fold line, and wherein liner tray further comprises a relief slit at least approximately aligned with the fold line and adjacent to the first fitment aperture.

[c67] 67. The corrugated container assembly of claim 63 wherein the first and second fitment apertures have keyhole shapes.

[c68] 68. The corrugated container assembly of claim 63 wherein the neck portion of the drain fitment has a rectangular cross-section.

[c69] 69. The corrugated container assembly of claim 63 wherein the container body includes an outer tube and an inner tube, the outer tube having a plurality of outer side panels foldably connected to each other, at least two of the outer side panels being foldably connected to each other along an outer corner portion that includes the first score line offset from the second score line by a first offset distance, the inner tube having a plurality of inner side panels foldably connected to each other, at least two of the inner side panels being foldably connected to each other along an inner corner portion that includes a third score line offset from a fourth score line by a second offset distance, the inner tube being sleeved within the outer tube to form the plurality of vertical side walls foldably connected to each other.

[c70] 70. The corrugated container assembly of claim 69 wherein the first offset distance is greater than the second offset distance.

[c71] 71. The corrugated container assembly of claim 69 wherein the outer tube includes first and second plies and the inner tube includes third, fourth, and fifth plies, and wherein the first, second, third, fourth and fifth plies are double-wall corrugated paperboard.

[c72] 72. The corrugated container assembly of claim 69 wherein the inner tube has an inner tube inner surface and an inner tube outer surface and the outer tube has an outer tube inner surface and an outer tube outer surface, and wherein the first and second score lines are formed on the outer tube inner surface and the third and fourth score lines are formed on the inner tube inner surface.

[c73] 73. A foldable multi-wall corrugated container structure comprising:
a laminate forming a plurality of wall panels including at least a first panel
and a second panel, the laminate having a first score line offset from

a second score line by an offset distance, the first and second score lines being positioned between the first and second panels to form a corner portion between the first and second panels, wherein the first and second panels are foldable toward each other about the corner portion to form a multi-wall container.

[c74] 74. The corrugated container structure of claim 73 wherein the laminate includes first and second plies.

[c75] 75. The corrugated container structure of claim 73 wherein the first and second plies are double-wall corrugated paperboard.

[c76] 76. The corrugated container structure of claim 73 wherein the laminate has a laminate thickness and the offset distance is determined based on the laminate thickness.

[c77] 77. The corrugated container structure of claim 73 wherein the laminate has a laminate thickness and the offset distance is at least approximately equal to twice the laminate thickness.

[c78] 78. The corrugated container structure of claim 73 wherein the laminate has an inner surface and an outer surface and the first and second score lines are formed on the inner surface.

[c79] 79. A method for producing a foldable corrugated container structure, the method comprising:
 providing a laminate;
 scoring the laminate to produce a first score line; and
 scoring the laminate to produce a second score line offset from the first score line, the first and second score lines defining a first panel and

a second panel of the laminate, wherein the first and second score lines together define a corner portion, and wherein the first and second panels are foldable toward each other about the corner portion.

[c80]

80. The method of claim 79 wherein providing the laminate includes providing an outer laminate, wherein scoring the laminate to produce the first and second score lines includes scoring the outer laminate to produce the second score line offset from the first score line by a first offset distance, the first and second score lines defining a first outer panel and a second outer panel of the outer laminate, and wherein the method further comprises:

providing an inner laminate;

scoring the inner laminate to produce a third score line;

scoring the inner laminate to produce a fourth score line offset from the third score line by a second offset distance, the third and fourth score lines defining a first inner panel and a second inner panel of the inner laminate;

positioning the first inner panel of the inner laminate adjacent to the first outer panel of the outer laminate to form a first wall; and

positioning the second inner panel of the inner laminate adjacent to the second outer panel of the outer laminate to form a second wall, wherein the first and second score lines of the outer laminate and the third and fourth score lines of the inner laminate together define the corner portion, and wherein the first and second walls are foldable toward each other about the corner portion.

[c81]

81. The method of claim 80 wherein scoring the inner laminate includes scoring the inner laminate to produce the fourth score line offset from the third score line by the second offset distance, the second offset distance being less than the first offset distance.

[c82] 82. The method of claim 80 wherein providing the outer laminate includes providing the outer laminate having first and second plies, and wherein providing the inner laminate includes providing the inner laminate having third, fourth and fifth plies.

[c83] 83. The method of claim 80 wherein providing the outer laminate includes providing the outer laminate having first and second plies of double-wall corrugated paperboard, and wherein providing the inner laminate includes providing the inner laminate having third, fourth and fifth plies of double-wall corrugated paperboard.

[c84] 84. The method of claim 80 wherein providing the outer laminate includes providing the outer laminate having an outer laminate inner surface and an outer laminate outer surface, wherein scoring the outer laminate includes scoring the outer laminate to produce the first and second score lines on the outer laminate inner surface, wherein providing the inner laminate includes providing the inner laminate having an inner laminate inner surface and an inner laminate outer surface, and wherein scoring the inner laminate includes scoring the inner laminate to produce the third and fourth score lines on the inner laminate inner surface.

[c85] 85. A method for producing a liner tray usable with a liner for holding liquids, the liner including a drain fitment for dispensing the liquids, the drain fitment having a neck portion and a flange adjacent to the neck portion, the method comprising:

forming a base member;

forming a fitment retainer extending from the base member;

forming first and second fitment apertures in the fitment retainer, the first and second fitment apertures each having an oversize portion and an engagement portion, the oversize portions being shaped and

sized to permit passage of the flange of the drain fitment and the engagement portions being shaped and sized to receive and engage the neck portion of the drain fitment, the first and second fitment apertures being positionable in at least approximate alignment with each other; and

forming a third fitment aperture in the fitment retainer, the third fitment aperture being shaped and sized to releasably receive the neck portion of the drain fitment, the third fitment aperture being positionable in at least approximate alignment with the engagement portions of the first and second fitment apertures.

[c86] 86. The method of claim 85 further comprising forming a plurality of slits in the fitment retainer extending radially from the third fitment aperture sized to allow the third fitment aperture to pass over the flange of the drain fitment and releasably receive the neck portion of the drain fitment.

[c87] 87. The method of claim 85 wherein forming the fitment retainer includes forming the fitment retainer extending from the base member along a fold line, and wherein the method further comprises forming a relief slit at least approximately aligned with the fold line and adjacent to the first fitment aperture.

[c88] 88. The method of claim 85 wherein forming the first and second fitment apertures includes forming the first and second fitment apertures having keyhole shapes.

[c89] 89. The method of claim 85 wherein forming the third fitment aperture includes forming the third fitment aperture having a generally rectangular shape, and wherein the method further comprises forming a slit extending diagonally from each corner of the third fitment aperture and forming a slit extending perpendicularly from each side of the third fitment aperture.

[c90] 90. The method of claim 85 wherein forming the base member and forming the fitment retainer include forming the base member and forming the fitment retainer from noncorrugated paperboard.

[c91] 91. A liner tray usable with a liner for holding liquids, the liner including a drain fitment for dispensing the liquids, the liner tray comprising:
a base member;
a fitment retainer extending from the base member along a fold line, at least a portion of the fitment retainer being configured to receive the drain fitment; and
a relief slit at least approximately aligned with the fold line adjacent to the portion of the fitment retainer configured to receive the drain fitment.

[c92] 92. The liner tray of claim 91 wherein the fold line is a first fold line and the fitment retainer includes:
a first fitment retainer panel extending from the base member along the first fold line, the first fitment retainer panel having a first fitment aperture shaped and sized to receive the drain fitment; and
a second fitment retainer panel extending from the first fitment retainer panel along a second fold line that is at least approximately parallel to the first fold line, the second retainer panel having a second fitment aperture shaped and sized to receive the drain fitment, the second fitment retainer panel being foldable about the second fold line to position the second fitment aperture adjacent to the first fitment aperture.

[c93] 93. The liner tray of claim 92 wherein the first and second fitment apertures have keyhole shapes.

[c94] 94. The liner tray of claim 92 wherein the fitment retainer further includes a third fitment retainer panel extending from the second fitment retainer panel along a third fold line that is at least approximately perpendicular to the first and second fold lines, the third fitment retainer having a third fitment aperture shaped and sized to receive the drain fitment, wherein the third fitment retainer panel is foldable about the third fold line to position the third fitment aperture adjacent to the first and second fitment apertures.

[c95] 95. The liner tray of claim 94 wherein the third fitment retainer panel further includes a plurality of slits extending radially from the third fitment aperture sized to allow the third fitment aperture to pass over at least a portion of the drain fitment.

[c96] 96. The liner tray of claim 94 wherein the drain fitment includes a neck portion and a flange adjacent to the neck portion, wherein:

the first and second fitment apertures each have an oversize portion and an engagement portion, the oversize portions being shaped and sized to permit passage of the flange of the drain fitment and the engagement portions being shaped and sized to receive and engage the neck portion of the drain fitment; and

the third fitment aperture is shaped and sized to releasably receive the neck portion of the drain fitment, the third fitment aperture being positionable in at least approximate alignment with the engagement portions of the first and second fitment apertures.

[c97] 97. The liner tray of claim 96 wherein the first and second fitment apertures have keyhole shapes and the third fitment aperture has a generally rectangular shape, and wherein a slit extends diagonally from each corner of the third fitment aperture and a slit extends perpendicularly from each side of the third fitment aperture.

[c98] 98. The liner tray of claim 96 wherein the neck portion of the drain fitment has a rectangular cross-section.

1000 980 970 960 950 940 930 920 910 900 890 880 870 860 850 840 830 820 810 800 790 780 770 760 750 740 730 720 710 700 690 680 670 660 650 640 630 620 610 600 590 580 570 560 550 540 530 520 510 500 490 480 470 460 450 440 430 420 410 400 390 380 370 360 350 340 330 320 310 300 290 280 270 260 250 240 230 220 210 200 190 180 170 160 150 140 130 120 110 100 90 80 70 60 50 40 30 20 10 0